

Date: Thursday, 28/05/2009 11:50:30 AM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 48281		
Estimate Number	: 11175		
P.O. Number	:	Part Number	: D22825
This Issue	: 28/05/2009 S.O. No. :	Drawing Number	: D2282 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 46429	Material	:
Written By	:	Due Date	: 04/06/2009 Qty: 50 Um: Each
Checked & Approved By	: <u>JUD 09.05.28</u>		
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM EstRev:B Now on Doosan Lathe 08-06-05 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R0750	304 SS Roundbar .750
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Comment: Qty.: 0.1891 f(s)/Unit Total : 9.4532 f(s)
 Material: AISI 304 Stainless Steel Ø0.750(M304R0.750)
 Batch 111323

128 09.06.04

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE
 1-Turn as per Dwg D2282 and Folio FA189

2-Deburr

128 09.06.04

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

45
128 09.06.04

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

128 09/06/05

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Eric L.

128 09/06/08 45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: TUBE

Job Number: 48281

Part Number: D22825

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/08 *[Signature]*

Job Completion



mf 09-06-08

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DART AEROSPACE LTD		Work Order: 728281	
Description: Handle Tube		Part Number: D2282-5	
Inspection Dwg: D2282 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.17	+/-0.030	2.150	/			
R0.063	+/-0.010	R0.063	/			
0.063	+/-0.010	.063	/			
0.125	+/-0.010	.125	/			
0.090 x 45°	+/-0.010	.090 x 45°	/			
R0.350	+0.010/-0.000	R.350	/			
0.158	+/-0.010	.158	/			
Ø0.386	+0.005/-0.000	.388	/			
Ø0.700	+/-0.010	.700	/			

Measured by: [Signature]	Audited by: J.L.	Prototype Approval:	N/A
Date: 09.06.04	Date: 09/06/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	[Signature]

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

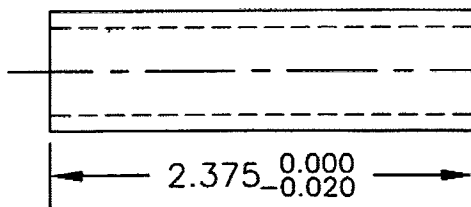
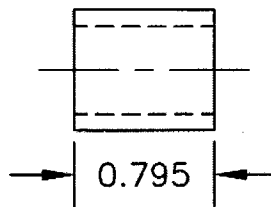
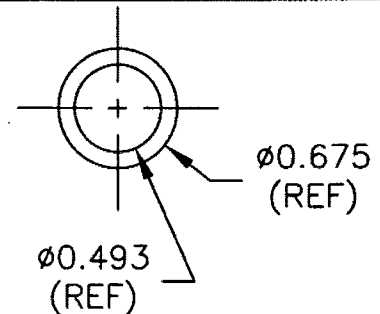
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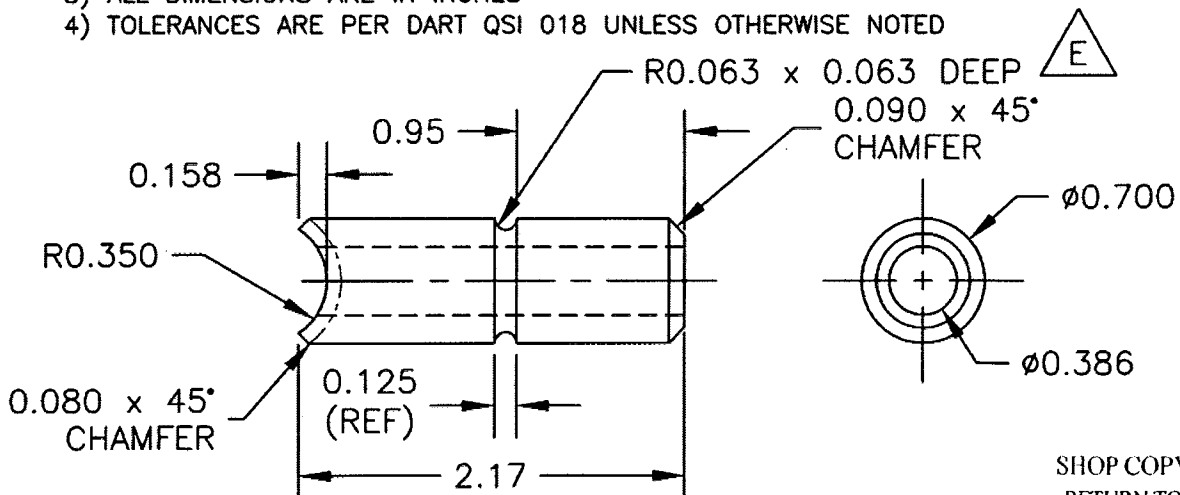
DART**RELEASED**

05/09/16

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
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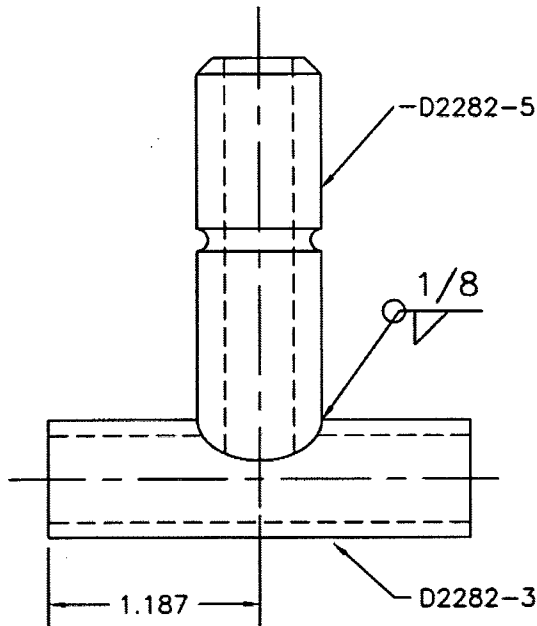
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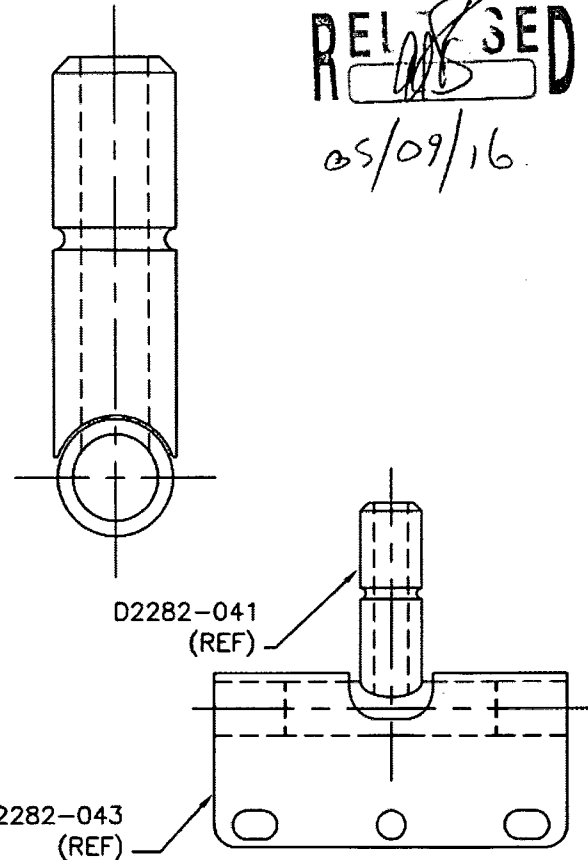
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DART

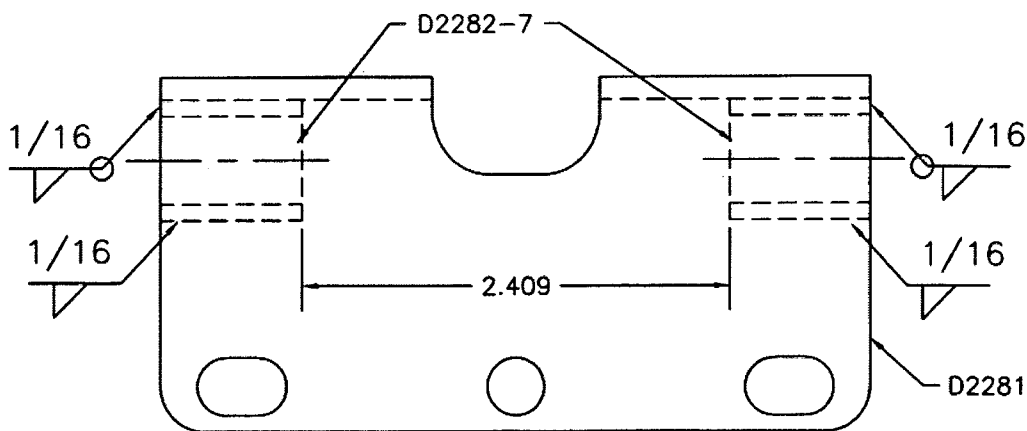
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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